

Work Order ID 64166

Thursday, November 25, 2010 4:03:12 PM

PRELIMINARY ISSUE

Page 1

Item ID: D4298-001**Revision ID:** PREI IM**Item Name:** Chart Holder Assembly**Start Date:** 11/25/2010 **Start Qty:** 1.00**Accept****Setup****Start****Required Date:** 12/3/2010 **Req'd Qty:** 1.00**Cust Item ID:****Customer:****Reference:****Approvals:** Process Plan: MDate: 10/11/26

Tooling:

Date:

Run**Start**

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

Draw Nbr	Revision Nbr								
D4298	PA1								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

110



Small Fab

Memo

0.00

SD 10/12/17W

Small Fab

Assemble as per dwg

120



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64166

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Thursday, November 25, 2010 4:03:12 PM

Item ID: D4298-001

Revision ID: PPELIM

Item Name: Chart Holder Assembly

Start Date: 11/25/2010 Start Qty: 1.00

Required Date: 12/3/2010 Req'd Qty: 1.00

Accept



Setup Start



Stop



Cust Item ID:



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

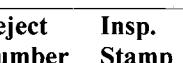
SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Barcode	Identify as per dwg & Stock Location: Packaging	0.00							
140 Barcode	QC21- Final Inspection - Work Order Release QC Quality Control	0.00							



POSITIVE RECALL

EFFECTIVE 10.11.29 AUTH JARELEASED DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, November 25, 2010 4:03:18 PM

Page 1

Work Order ID: 64166



Parent Item: D4298-001



Parent Item Name: Chart Holder Assembly

Start Date: 11/25/2010

Required Date: 12/3/2010

Comments: IPP revA 11.10.25 new issue EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4298-002 		Manufactured	No		B 64165		Each	0.0000	1	1		<u>SB 10/12/15</u>	
Plate Assembly													
D4298-003 		Manufactured	No		B 64164		Each	0.0000	1	1		<u>SB 10/12/15</u>	
Plate Assembly													
D4298-004 		Manufactured	No		B 64163		Each	0.0000	1	1		<u>SB 10/12/15</u>	
Fixing Bracket Assembly													
D4298-006 		Manufactured	No		B 64162		Each	0.0000	1	1		<u>SB 10/12/15</u>	
Machined Inner Assembly													
D4298-007 		Manufactured	No		B 64161		Each	0.0000	1	1		<u>SB 10/12/15</u>	
Machined Outer Assembly													
D4298-013 		Manufactured	No				Each	0.0000	1	1			
Hinge													
D4298-014 		Manufactured	No		B 64156		Each	0.0000	1	1		<u>SB 10/12/15</u>	
Hinge													
D4298-020 		Manufactured	No		B 64155		Each	0.0000	1	1		<u>SB 10/12/15</u>	
Knob													
					B 64150		Each	0.0000	2	2		<u>SB 10/12/15</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Thursday, November 25, 2010 4:03:18 PM

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Parent Item: D4298-001



Parent Item Name: Chart Holder Assembly

Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

D4298-021



Manufactured No

B 64149

Each

0.0000

1

1

SB 10/12/15

Machined Bolt

D4298-022



Manufactured No

B 64148

Each

0.0000

1

1

SB 10/12/15

Pin Topper

D4298-023



Manufactured No

B 64147 B64749

Each

0.0000

1

1

SB 10/12/15

Pin

MS171441



Purchased No

M 116355

Each

0.0000

1

1

SB 10/12/15

Spring Pin

MS20392-3C15



Purchased No

M 116290
104156

Each

0.0000

1

1

SB 10/12/15

Pin, Straight Head

MS24665-103



Purchased No

M 116355

Each

0.0000

1

1

SB 10/12/15

Cotter Pin

MS24693-C246



Purchased No

M 116355

Each

0.0000

4

4

SB 10/12/15

Screw

MS27039C1-09



Purchased No

M 116290

Each

49.0000

3

3

SCREW

Location

ST293

Loc Qty

49

Loc Code

17831

49

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Thursday, November 25, 2010 4:03:18 PM

Work Order ID: 64166



Parent Item: D4298-001



Parent Item Name: Chart Holder Assembly

Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

Each

343.0000

3

3



Washer

Location	Loc Qty	Loc Code
ST298	343	
114348	1	
114884	161	
116169	181	

M 14 290

3

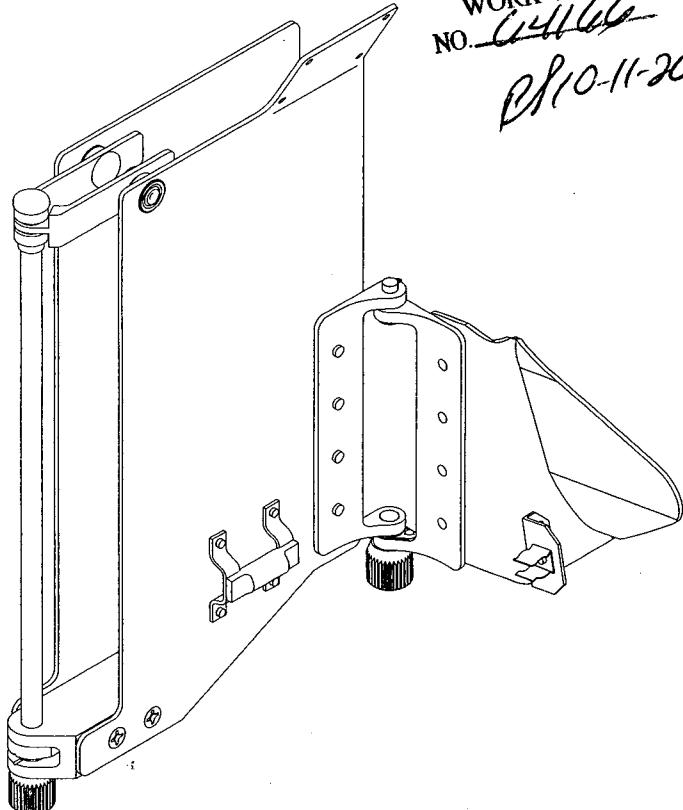
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. C41164
D810-11-26

REVISION

LETTER	DRFTSMN	DATE	DESCRIPTION	APPROVED	DATE
IR	DNN	9/8/10	INITIAL RELEASE.		
A	DNN	11/12/10	MAT'L CHG. FOR ITEMS 8 THRU 20; CHG. GRIP ON 20; UPDATED P/N'S.		

	4		(37) AN426AD4-()	RIVET				
	4		(36) AN426AD3-()	RIVET				
	1		(35)	C-CLIP				
2			(34) MS27980-6B	SOCKET, SNAP FASTENER				
2			(33) MS27980-1B	BUTTON, SNAP FASTENER				
	1	1	(32) MS27980-9B	POST, SNAP FASTENER				
	1	1	(31) MS27980-7B	STUD, SNAP FASTENER				
		4	(30) MS24693-C246	SCREW				
1	1	1	(29) MS171441	PIN, SPRING			(ALT P/N NAS561C2-13)	
	1		(28) MS24665-103	COTTER PIN				
	1		(27) MS20392-3C15	PIN, STRAIGHT HEADED				
3	26		NAS1149D0332J	WASHER				
3	25		MS27039C1-09	SCREW				
1	1	1	(24) -024	SERRATED ADJUSTMENT WASHER	STAINLESS STEEL			
		1	(23) -023	PIN	STAINLESS STEEL			
	1		(22) -022	PIN TOPPER	STAINLESS STEEL			
		1	(21) -021	MACHINE BOLT	STAINLESS STEEL			
2	20		(20) -020	KNOB	6061-T6 ALUM.			
1			(19) -019	MACHINED OUTER	6061-T6 ALUM.			
1			(18) -018	MACHINED INNER	6061-T6 ALUM.			
	2		(17) -017	CLIP STOP MOUNT	6061-T6 ALUM.			
	1		(16) -016	CLIP STOP	6061-T6 ALUM.			
1			(15) -015	CLIP ANGLE	.050	6061-T6 ALUM.		
1			(14) -014	HINGE	6061-T6 ALUM.			
1			(13) -013	HINGE	6061-T6 ALUM.			
1			(12) -012	HINGE	6061-T6 ALUM.			
	1		(11) -011	HINGE	6061-T6 ALUM.			
1			(10) -010	FIXING BRACKET	.093	LEXAN		
	1		(9) -009	PLATE	.080	6061-T6 ALUM.		
	1		(8) -008	PLATE	.080	6061-T6 ALUM.		
	1		(7) -007	MACHINED OUTER SUB-ASSY				
	1	6	(6) -006	MACHINED INNER SUB-ASSY				
	1	5	(5) -005	HINGE SUB-ASSY				
	1	4	(4) -004	FIXING BRACKET SUB-ASSY				
	1	3	(3) -003	PLATE SUB-ASSY				
	1	2	(2) -002	PLATE SUB-ASSY				
		1	(1) -001	CHART HOLDER ASSY				
-007-006-005-004-003-002-001	ITEM NO.		PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC.	ZONE

NO. REQ'D PER ASSY.

LIST OF MATERIAL

DRFTSMN	D. NELSON	9/8/10	TITLE
CHECK			SINGLE PILOT VFR
STRESS			CHART HOLDER, AW139
PROJ. ENGR.			
HEAT TREAT			
FINISH			
			Rev. A

Erta Helicopters LLC

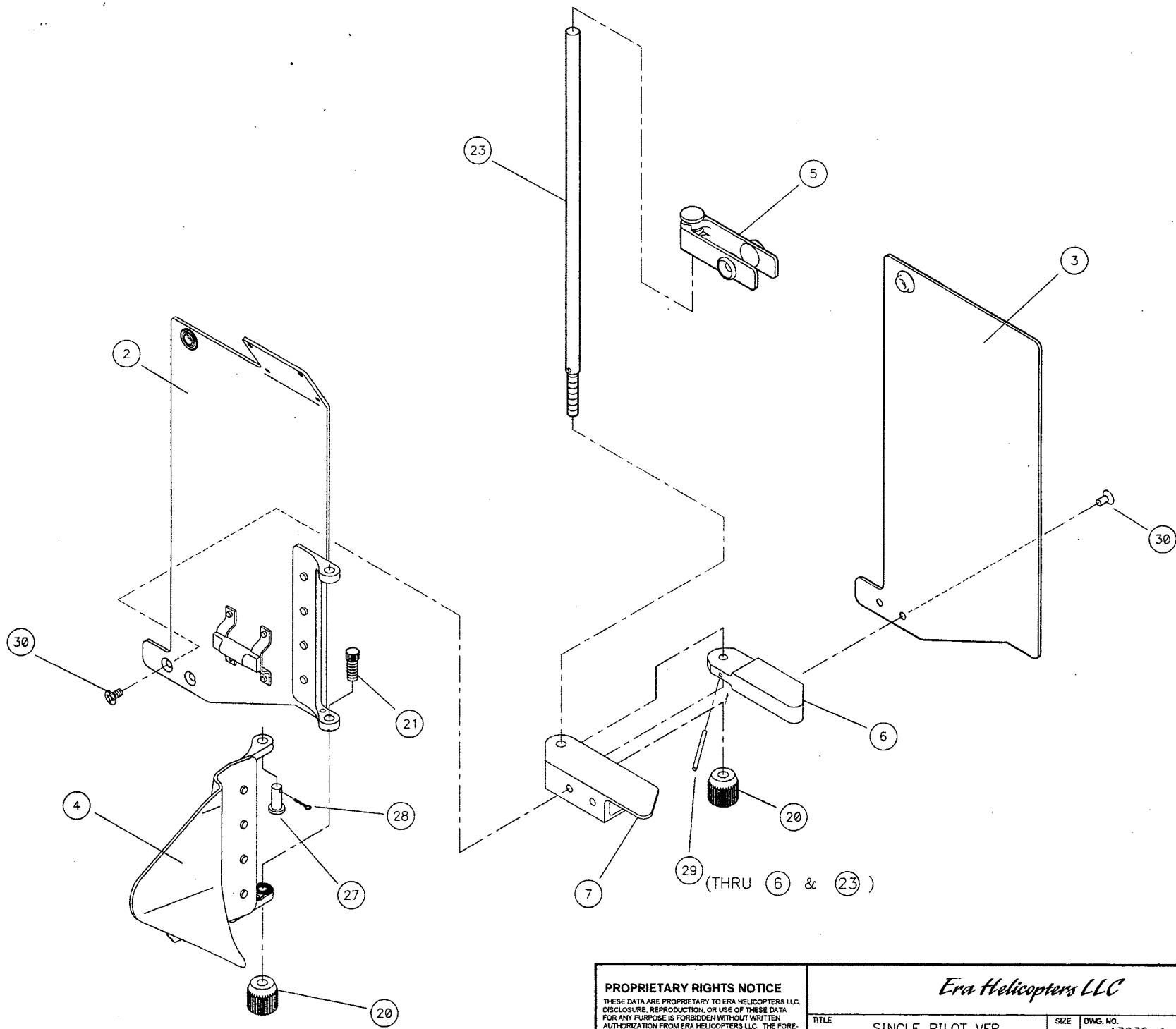
DWG. NO. 13939-1-290
SHT 1 OF 10

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AVT ASSEMBLY

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Era Helicopters LLC

TITLE

SINGLE PILOT VFR
CHART HOLDER, AW139

SIZE

C

DWG. NO.
13939-1-290
SHT 2 OF 10

REV.

A

Eric Charbonneau

From: Domingue, Elvin [edomingue@erahelicopters.com]
Sent: December 17, 2010 10:24 AM
To: Nelson, David; 'echarbonneau@dartaero.com'
Subject: Re: washer addition

I agree David

Elvin Domingue
Sent from my BlackBerry Wireless Device

From: Nelson, David
To: 'Eric Charbonneau' <echarbonneau@dartaero.com>
Cc: Domingue, Elvin
Sent: Fri Dec 17 09:23:20 2010
Subject: FW: washer addition
Hi Eric,

That looks good. The added washer seems fine. The only other thing I would add is that all exposed hardware and surfaces would be painted.

But I'll let Elvin decide those issues.

I'll update and re-send the drawing with the knob depth fix, and add the other changes once approved.

Thanks,
David

From: Eric Charbonneau [<mailto:echarbonneau@dartaero.com>]
Sent: Friday, December 17, 2010 8:24 AM
To: Nelson, David
Subject: washer addition

Good morning David, for better function we added one AN960JD416 under both knob (see attached mark-up) please let me know if this is ok with and also I noticed on p9. of the drawing there's a typo on the depth of the threaded hole for the knob... should be 0.60" deep not 0.06". I Also attached a picture of the completed ass'y... looks pretty good.

Regards,

ERIC CHARBONNEAU
Production Engineering Coordinator



T(613) 632-5200
F(613) 632-1053
echarbonneau@dartaero.com

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